

Work Order ID 163282

Tuesday, June 27, 2017 12:01:45 PM

163282

Page 1

Item ID: D3773-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Adapter

Start Date: 6/20/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/21/2017 Req'd Qty: 4.00

4

Customer:

Reference:

JUL 03 2017

Approvals:

Process Plan:

DAS
21

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3773	Rev B

100

0.00

100

BAND SAW

Bandsaw

Memo

0.50

Jeaspa Bandsaw

Cut blank 2.700" long

4x	Ø	2017/07/07 mm mk
----	---	------------------------

110

1.63

110

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

1.69

HAAS CNC vertical machine #1

1- Mill as per Folio FA740 Rev: _____ & Dwg D3773 Rev: _____ 2-Deburr
per dwg D3773

4x	Ø	2017/07/10 mm mk
----	---	------------------------

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.04

Quality Control

4x	Ø	2017/07/10 mm mk
----	---	------------------------

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

Work Order ID 163282***163282***

Page 2

Tuesday, June 27, 2017 12:01:45 PM

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Adapter

Start Date: 6/20/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/21/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.08

Quality Control

4

17-07-10

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.04

Packaging

LOCATION WA002

4

DAS
9-89

JUL 12 2017

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.40

Quality Control

17/7/13

17.07.12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Tuesday, June 27, 2017 12:01:43 PM

Page 1

Work Order ID: 163282

163282

Parent Item: D3773-1

D3773-1

Parent Item Name: Adapter

Start Date: 6/20/2017

Required Date: 7/21/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-05-07 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased			No	100	f	23.3750	0.225	0.947368			

M304B1 500X1 500

**

M304A1.25X1.25X.188W

17-07-09 M.M.
mf

Location

Loc Qty

Loc Code

MAT009

23.375

M137515

23.375

.921

DQA: _____ Date: _____



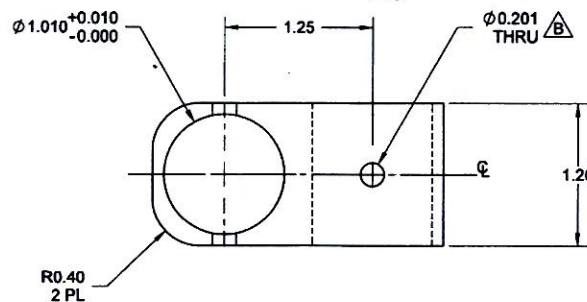
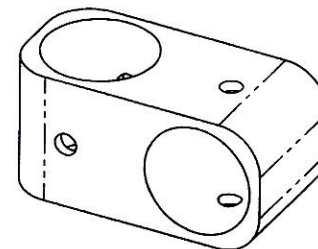
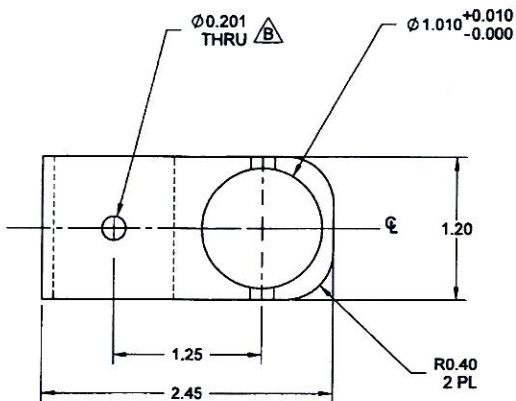
WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																																																														

5065



D3773-1 ADAPTER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163282
ML5
120703

- NOTES:
- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.40 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3773	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HEADREST ADAPTER	NTS
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